

Aero Design Ltd.**Work Order Control Sheet**Work Order#: **2017-142** Date Opened: **25 August 2017** Title: **Assembly**Aircraft OEM: **Bell** Aircraft Model: **429** Product Type: **Cabin Step** Product Model: **Standard** Quantity: **3-Fixed, 2-QR****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
96910	1	Fixed Step	JC
96911	1	Quick Release Step Assy	JC
96920	1	Step Bracket	JC
96921	1	Step Bracket	JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

3,2
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
DM
N/A
N/A
JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: Jeff Clarke

Sign: 

SCA: AD02

Date: 21 Sept. 2017

ICC / Dual Inspection performed by:

Print: Jason Rekve

Sign: 

SCA: AD01

Date: 21 Sept. 2017

Work Order closed by:

Print: Jeff Clarke

Sign: 

SCA: AD02

Date: 8 Dec. 2017

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0462
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-142
6. Item 1.	7. Description Fixed Step	8. Part Number 96910-01	9. Qty. 1	10. Serial/Batch No. N/A	11. Status/Work New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 8 Dec. 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
Installer Responsibilities					
This certificate does not constitute authority to install.					
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.					
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0461
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-142
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Fixed Step	96910-01	1	N/A	New
2.	Quick Release Step	96911-01	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 	13c. Approved Organization Number AMF 73-04		14b. Signature	14c. Approved Organization Number	
13d. Name Jeff Clarke - AD02	13e. Date (dd/mm/yyyy) 7 Dec. 2017		14d. Name	14e. Date (dd/mm/yyyy)	
Installer Responsibilities					
This certificate does not constitute authority to install.					
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.					
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

Bell Helicopters



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bell 429 Cabin Step No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 96910-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-142
Remaining Tasks to be Performed: See reverse

Signature: [Signature]
Date: Aug 28 / 2017

Lic. No. / SCA AD 73-04 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps 7, Clean up ✓

8, Inspect ✓

9, Finish paint or powder ✓ PO 170F8

10, Assemble ✓

11, Inspect. ✓



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bell 429 Cabin Step No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 96911-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-142

Remaining Tasks to be Performed: See reverse

Signature: [Signature]

Date: Aug 28 / 2017 Lic. No. / SCA AD 73-04 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 7. Clean up ✓
8. Inspect ✓
9. Finish, coating ✓ Po 17088
10. Assemble ✓
11. Inspect. ✓



2017-142
WO# ~~2017-204~~ C13

Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0380
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3				5. Work Order/Contract/Invoice WO 2017-142	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Fixed Step	96910-01	1	N/A	New
2.	Quick Release Step	96911-01	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature		13c. Approved Organization Number	14b. Signature		14c. Approved Organization Number
 AD 73-04 02		AMF 73-04			
13d. Name		13e. Date (dd/mmm/yyyy)	14d. Name		14e. Date (dd/mmm/yyyy)
Jeff Clarke - AD02		02 Oct 2017			
Installer Responsibilities					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

HANGAR ONE



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bell 429 Cabin Step No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 96910-01 rev 1 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-142

Remaining Tasks to be Performed: See reverse

Signature: [Signature]

Date: Aug 28 / 2017 Lic. No. / SCA 73-04 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 7; Clean up ✓

8; Inspect ✓

9; Finish paint or powder ✓ Po 17085

10; Assemble ✓

11; Inspect ✓



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bell 429 Cabin Step No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 96911-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-142

Remaining Tasks to be Performed: See reverse

Signature: David Marty

Date: Aug 28 / 2017 Lic. No. / SCA 73-04 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 7. Clean up ✓

8. Inspect ✓

9. Finish, coating ✓ PO 17085

10. Assemble ✓

11. Inspect. ✓

Aero Design

Parts Distribution Sheet

Hangar One
29 sept 2017

Description: Bell 429 Cabin Steps

WO# 2017-142

[illegible]

CABIN STEP FABRICATION

FIXED

Work Order: 2017-142

Batch Quantity: 238

Date Open: 25 Aug 2017

General

These instructions apply to Step Assemblies for various models of helicopter listed below. Refer to the following drawings, at the current revision, for dimensions and details:

✓	Make/Model	Step		
		Ass'y	End 1	End 2
	<i>Bell</i>			
	206L/407/205/212 Cabin Step	80010	80020	
	206B Cabin Step	87810	87820	87821
✓	429 – Fixed Cabin Step	96910	96920	
	429 – Quick Release Cabin Step	96911	96921	
	<i>Airbus Helicopters</i>			
	AS350/AS355 Quick Release Maintenance Step	82716	82722	
	AS350/AS355 Extended Quick Release Maintenance Step	82711	82720	82720
	<i>MD600</i>			
	Cabin Step	82910	80021	

Complete
(initial or SCA #)

1. End Bracket Stock Preparation

a. Cut 6061-T6 aluminum material for end brackets:

	Model	P/N	Stock Bar	Qty per bar
i.	206L/407/205/212	80020-01/-02:	3.5 x 1 @ 16.75 long	(2 left / 2 right)
ii.	MD600	80021-01/-02:	3.5 x 1 @ 16.75 long	(2 left / 2 right)
iii.	AS350	82720-01/-02:	3.5 x 1 @ 17.0 long	(2 left / 2 right)
iv.	AS350	82720-03:	3.5 x 1 @ 17.0 long	(4 parts)
v.	AS350	82722-01/-02:	4 x 1 @ 18.75 long	(2 left / 2 right)
vi.	206B	87820/21-01	4.5 x 1 @ 15.5 long	(2 left / 2 right)
vii.	429	96920-01/-02:	4 x 1 @ 15.5 long	(1 left / 1 right)
viii.	429	96921-01/-02:	6 x 1 @ 23.0 long	(2 left / 2 right)

b. Record material PO.

c. De-burr cut ends using buffing wheel on bench grinder.

d. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining.

2. CNC Machining

a. Load long vise jaws on vises. Max 0.15 depth of ledge on jaw.

b. Run CNC program to machine holes in edges of stock, and to machine parts from stock.

c. Update tag and place parts on in-progress shelf in welding shop for welding.

3. Deburring

- Deburr all outside edges of brackets using buffing wheel on bench grinder.
- Update tag and place parts on in-progress shelf in machine shop for insertion of helicoils.

jc

4. Helicoil Installation

- Install 3/8-24 helicoil into end brackets with Loctite 243.
- Record helicoil PO.
- Update tag and place parts on in-progress shelf in welding shop for welding.

N/A

5. Step Stock Preparation

- Cut step extrusion as indicated.

NOTE: 78230 is the "old" rectangular shape with a flange; 78240 is the "new" triangular shape.

i. 205/212	80010-7100:	Extrusion 78230 @ 70.25 long
ii. 206L/407	80010-7475:	Extrusion 78230 @ 74.00 long
iii. AS350	82711-01-XX:	Extrusion 78230 @ 75.25 long
iv. AS350	82716-01:	Extrusion 78240 @ 55.50 long
v. MD600	82910-01:	Extrusion 78230 @ 46.00 long
vi. 206B	82710-01:	Extrusion 78230 @ 80.50 long
vii. 429	96920-01/-02:	Extrusion 78240 @ 74.00 long
viii. 429	96921-01/-02:	Extrusion 78240 @ 74.00 long

- Record material PO.
- 82711-01-XX only: Trim forward end down to flange in accordance with drawing using radial arm saw.
- 82711-01-XX, 82910-01, 87810-01 only: Cut end cap(s) from 0.125 6061-T6 Sheet.
Record material PO
- Drill vent holes as indicated.
- Deburr cut edges and vent holes.
- Tag in-progress parts and place on in-progress shelf in welding shop for welding.

6. Welding

- Insert end bracket into ends or onto extrusion (as applicable). Use jig to set spacing of brackets.
- Weld around step extrusion using ER4043 rod.
- Record welding rod PO.
- Yellow tag step assemblies and place in-progress shelf in machine shop for clean up

*AD
73-04
05*

7. Clean up

- Clean up all welds using maroon scotch brite pad.
- Update tag and place parts on in-progress shelf in machine shop for inspection.

*(2)
AD
73-04
02*

8. Inspection

To be completed by a different person than the previous steps.

- Inspect Step Assemblies for conformity to drawings.
- Update tag and place parts on in-progress shelf in machine shop for surface finish.

*(1)
AD
73-04
02*

• CABIN STEP FABRICATION

Complete
(initial or S/N#)

9. Surface Finish

Parts may be painted or powder coated in accordance with the drawings.

- Paint in accordance with standard procedures.
- Powder coating is performed by an outside contractor. Record PO.
- Wingwalk grip paint is applied to the top surface of assemblies with the "old" extrusion. Grip paint is only applied to top surface with ridges, mask areas that are not to be coated.
- Update tag and place parts in stores for final assembly.

AD
73-04
02 (2)
CMB
73-04
02
(1)

10. Final Assembly

Note: not all steps may apply to all assemblies.

- Install 96710-01 Fitting into end brackets with two NAS1149F0663P Washers, 4 places.
- Adhere 3M Safety Walk 1" wide grip tape to top surface of steps in grooves provided.
- Record hardware and grip tape PO #s on PDS sheet for each assembly. Keep PDS sheet with completed assemblies before release.
- Assembled parts may be green tagged if not released immediately.

AD
73-04
02
(1)
AD
73-04
02
(1)

11. Final Inspection

To be completed by individual completing Form One. Sign off on Form One constitutes completion of this step.

- Inspect Step Assembly.
- Attach PDS sheet to Form One on release.

CABIN STEP FABRICATION

Work Order: 2017-142

Batch Quantity: 2

QR

Date Open: 25 AUG 2017

General

These instructions apply to Step Assemblies for various models of helicopter listed below. Refer to the following drawings, at the current revision, for dimensions and details:

✓	Make/Model	Step		
		Ass'y	End 1	End 2
	<i>Bell</i>			
	206L/407/205/212 Cabin Step	80010	80020	
	206B Cabin Step	87810	87820	87821
	429 – Fixed Cabin Step	96910	96920	
✓	429 – Quick Release Cabin Step	96911	96921	
	<i>Airbus Helicopters</i>			
	AS350/AS355 Quick Release Maintenance Step	82716	82722	
	AS350/AS355 Extended Quick Release Maintenance Step	82711	82720	82720
	<i>MD600</i>			
	Cabin Step	82910	80021	

Complete
(initial or SCA #)

1. End Bracket Stock Preparation

a. Cut 6061-T6 aluminum material for end brackets:

	Model	P/N	Stock Bar	Qty per bar
i.	206L/407/205/212	80020-01/-02:	3.5 x 1 @ 16.75 long	(2 left / 2 right)
ii.	MD600	80021-01/-02:	3.5 x 1 @ 16.75 long	(2 left / 2 right)
iii.	AS350	82720-01/-02:	3.5 x 1 @ 17.0 long	(2 left / 2 right)
iv.	AS350	82720-03:	3.5 x 1 @ 17.0 long	(4 parts)
v.	AS350	82722-01/-02:	4 x 1 @ 18.75 long	(2 left / 2 right)
vi.	206B	87820/21-01	4.5 x 1 @ 15.5 long	(2 left / 2 right)
vii.	429	96920-01/-02:	4 x 1 @ 15.5 long	(1 left / 1 right)
viii.	429	96921-01/-02:	6 x 1 @ 23.0 long	(2 left / 2 right)

b. Record material PO.

c. De-burr cut ends using buffing wheel on bench grinder.

d. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining.

2. CNC Machining

a. Load long vise jaws on vises. Max 0.15 depth of ledge on jaw.

b. Run CNC program to machine holes in edges of stock, and to machine parts from stock.

c. Update tag and place parts on in-progress shelf in welding shop for welding.

3. Deburring

- a. Deburr all outside edges of brackets using buffing wheel on bench grinder.
- b. Update tag and place parts on in-progress shelf in machine shop for insertion of helicoils.

JC

4. Helicoil Installation

- a. Install 3/8-24 helicoil into end brackets with Loctite 243.
- b. Record helicoil PO.
- c. Update tag and place parts on in-progress shelf in welding shop for welding.

JC

5. Step Stock Preparation

- a. Cut step extrusion as indicated.

NOTE: 78230 is the "old" rectangular shape with a flange; 78240 is the "new" triangular shape.

i. 205/212	80010-7100:	Extrusion 78230 @ 70.25 long
ii. 206L/407	80010-7475:	Extrusion 78230 @ 74.00 long
iii. AS350	82711-01-XX:	Extrusion 78230 @ 75.25 long
iv. AS350	82716-01:	Extrusion 78240 @ 55.50 long
v. MD600	82910-01:	Extrusion 78230 @ 46.00 long
vi. 206B	82710-01:	Extrusion 78230 @ 80.50 long
vii. 429	96920-01/-02:	Extrusion 78240 @ 74.00 long
viii. 429	96921-01/-02:	Extrusion 78240 @ 74.00 long

- b. Record material PO.
- c. 82711-01-XX only: Trim forward end down to flange in accordance with drawing using radial arm saw.
- d. 82711-01-XX, 82910-01, 87810-01 only: Cut end cap(s) from 0.125 6061-T6 Sheet.
Record material PO
- e. Drill vent holes as indicated.
- f. Deburr cut edges and vent holes.
- g. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD
73-04
05

6. Welding

- a. Insert end bracket into ends or onto extrusion (as applicable). Use jig to set spacing of brackets.
- b. Weld around step extrusion using ER4043 rod.
- c. Record welding rod PO.
- d. Yellow tag step assemblies and place in-progress shelf in machine shop for clean up.

(1) (1)
AD AD
73-04 73-04
02 02

7. Clean up

- a. Clean up all welds using maroon scotch brite pad.
- b. Update tag and place parts on in-progress shelf in machine shop for inspection.

(1) (1)
JC JC

8. Inspection

To be completed by a different person than the previous steps.

- a. Inspect Step Assemblies for conformity to drawings.
- b. Update tag and place parts on in-progress shelf in machine shop for surface finish.

CABIN STEP FABRICATION

Complete
(initial or SCA #)

9. Surface Finish

Parts may be painted or powder coated in accordance with the drawings.

- Paint in accordance with standard procedures.
- Powder coating is performed by an outside contractor. Record PO.
- Wingwalk grip paint is applied to the top surface of assemblies with the "old" extrusion. Grip paint is only applied to top surface with ridges, mask areas that are not to be coated.
- Update tag and place parts in stores for final assembly.

CMH
AD
73-04
02
(1)
AD
73-04
02
(1)

AD
73-04
02
(1)
AD
73-04
02
(1)

10. Final Assembly

Note: not all steps may apply to all assemblies.

- Install 96710-01 Fitting into end brackets with two NAS1149F0663P Washers, 4 places.
- Adhere 3M Safety Walk 1" wide grip tape to top surface of steps in grooves provided.
- Record hardware and grip tape PO #s on PDS sheet for each assembly. Keep PDS sheet with completed assemblies before release.
- Assembled parts may be green tagged if not released immediately.

11. Final Inspection

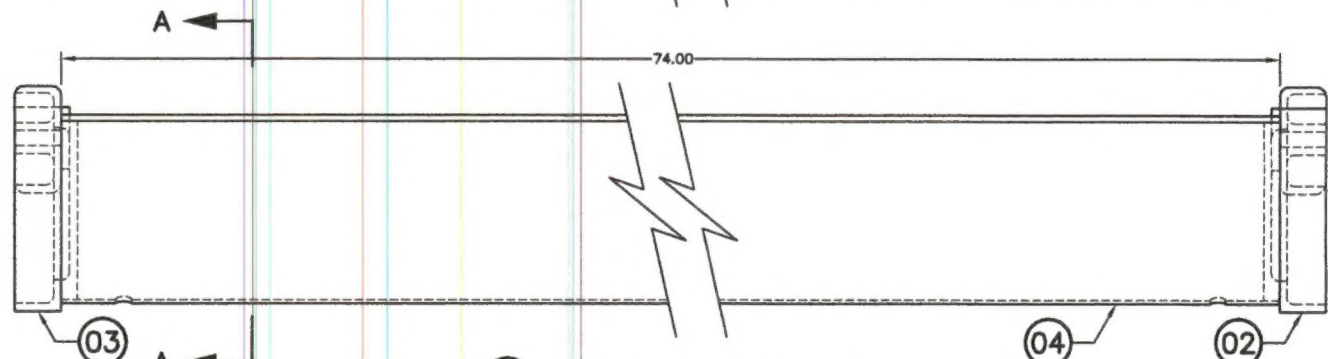
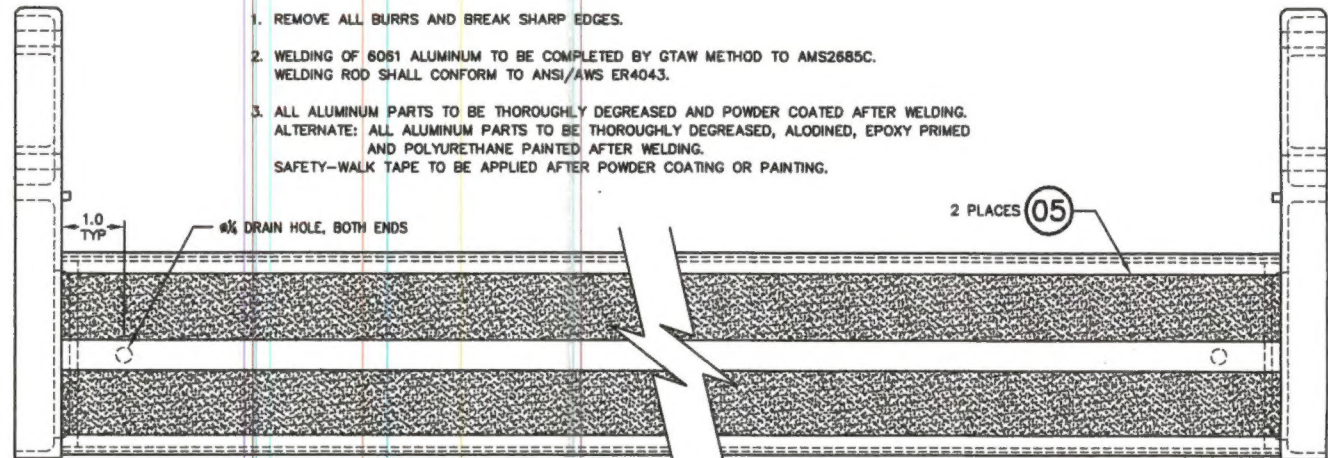
To be completed by individual completing Form One. Sign off on Form One constitutes completion of this step.

- Inspect Step Assembly.
- Attach PDS sheet to Form One on release.

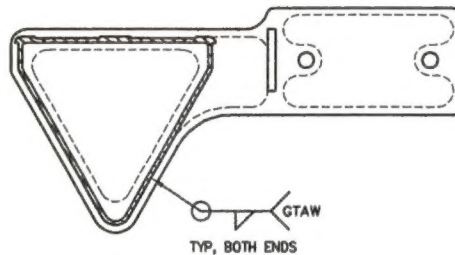
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; DRAIN HOLES ADDED; NOTE 3	BJC	08/05/2014

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ANSI/AWS ER4043.
3. ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED AFTER WELDING.
ALTERNATE: ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED, ALODINED, EPOXY PRIMED AND POLYURETHANE PAINTED AFTER WELDING.
SAFETY-WALK TAPE TO BE APPLIED AFTER POWDER COATING OR PAINTING.



01 FIXED STEP ASSEMBLY



SECTION A-A

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL
2	96910-05	05	SAFETY-WALK TAPE (1" WIDE)	3M
A/R	78240	04	STEP EXTRUSION	
1	96920-02	03	LH BRACKET	
1	96920-01	02	RH BRACKET	
	96910-01	01	FIXED STEP ASSEMBLY	

LIST OF MATERIALS

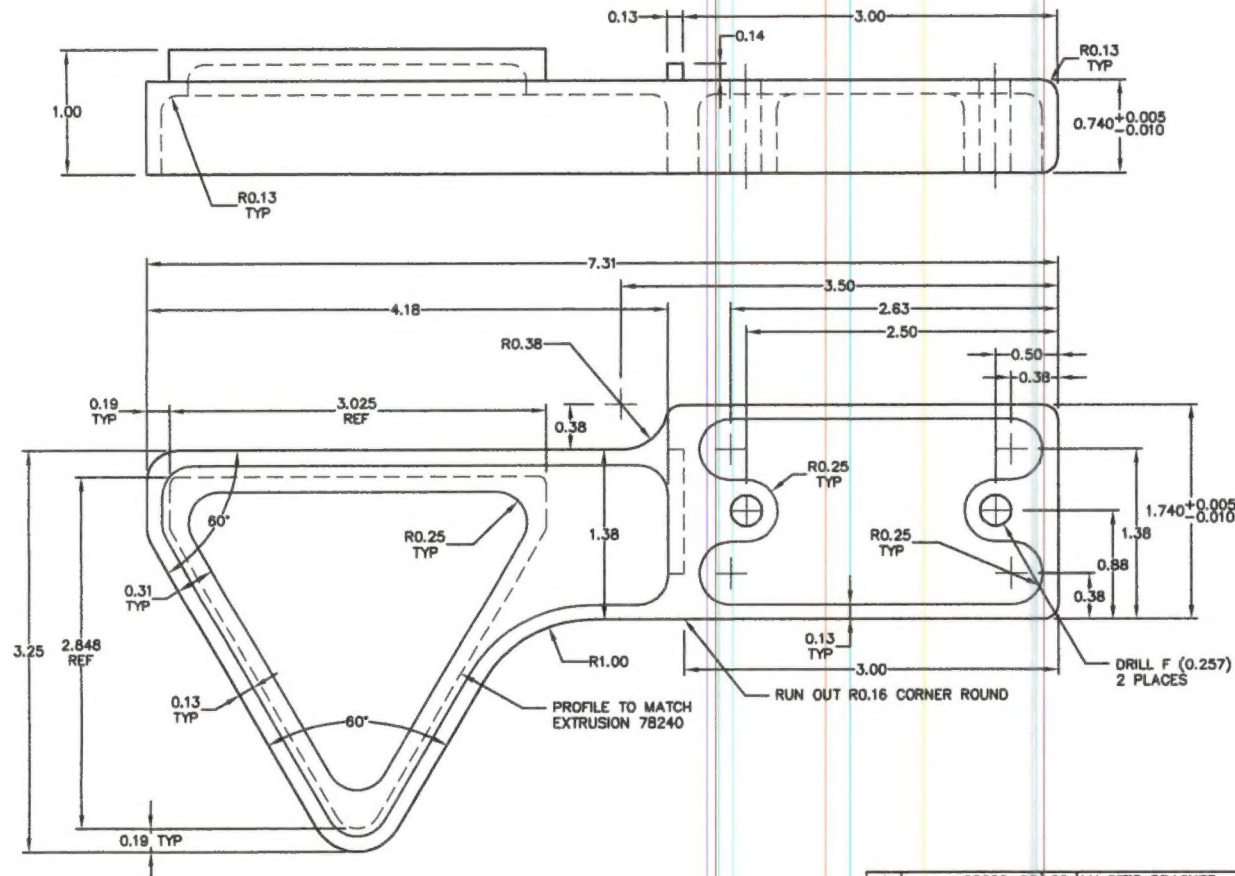
NOTICE: THIS DRAWING CONTAINS PROPRIETARY AND PATENTED INFORMATION. IT IS THE PROPERTY OF AERO DESIGN LTD. AND IS NOT TO BE REPRODUCED, COPIED, OR OTHERWISE USED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE CONSEQUENCES OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.

APPROVALS	DATE
DRAWN: JEFF CLARKE	14 SEPT 2012
CHECKED: E. BURGOIN	04 DEC 2012

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

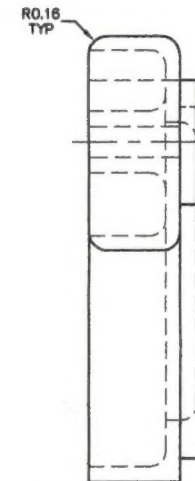
 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2370 www.aerodesign.ca		BELL 429 CABIN STEPS FIXED STEP ASSEMBLY	
		SCALE 1 : 2	REV. 1
SHEET 1 OF 1	DWG. SIZE A3	DWG. NO. 96910	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED	BJC	08/05/2014



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.



01 RH STEP BRACKET
02 LH STEP BRACKET
RH SHOWN, LH OPPOSITE

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	96920-02	02	LH STEP BRACKET	6061-T6 ALUMINUM	QQ-A-200/B	4 X 1 BAR
1	96920-01	01	RH STEP BRACKET	6061-T6 ALUMINUM	QQ-A-200/B	4 X 1 BAR

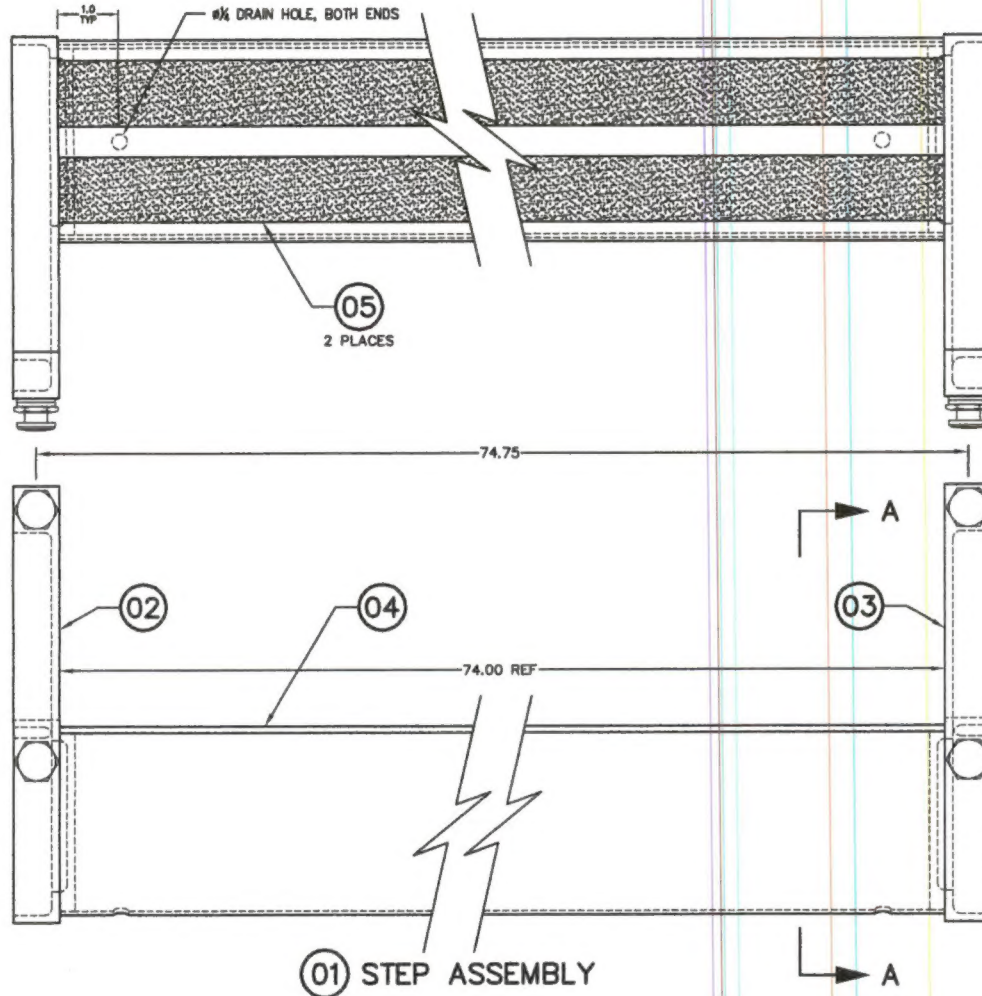
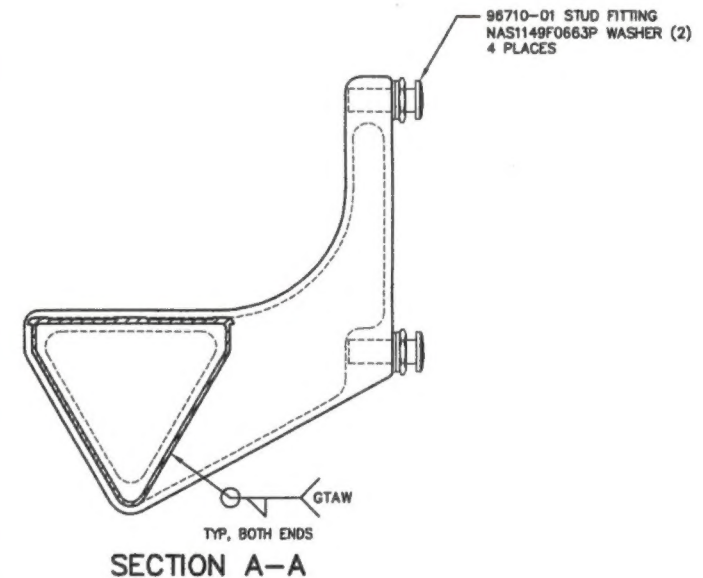
APPROVALS		DATE		AERO DESIGN LTD.	
DRAWN: JEFF CLARKE		14 SEPT 2012		9888A MALASPINA ROAD	
CHECKED: E. BURGAIN		04 DEC 2012		POWELL RIVER, BC, CANADA, V8A 0G3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				TEL: 604.483.3370 www.aerodesign.ca	
DECIMALS		ANGLES		BELL 429	
X.XXX ±0.010		±1/2°		CABIN STEPS	
X.XX ±0.03				FIXED STEP BRACKET FABRICATION	
X.X ±0.1					
SCALE 1 : 1		DWG. SIZE		REV.	
SHEET 1 OF 1		A3		96920	
				1	

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; DRAIN HOLES ADDED; NOTE 3	BJC	08/05/2014


NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ANSI/AWS ER4043.
3. ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED AFTER WELDING. ALTERNATE: ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED, ALODINED, EPOXY PRIMED AND POLYURETHANE PAINTED AFTER WELDING. SAFETY-WALK TAPE TO BE APPLIED AFTER POWDER COATING OR PAINTING.



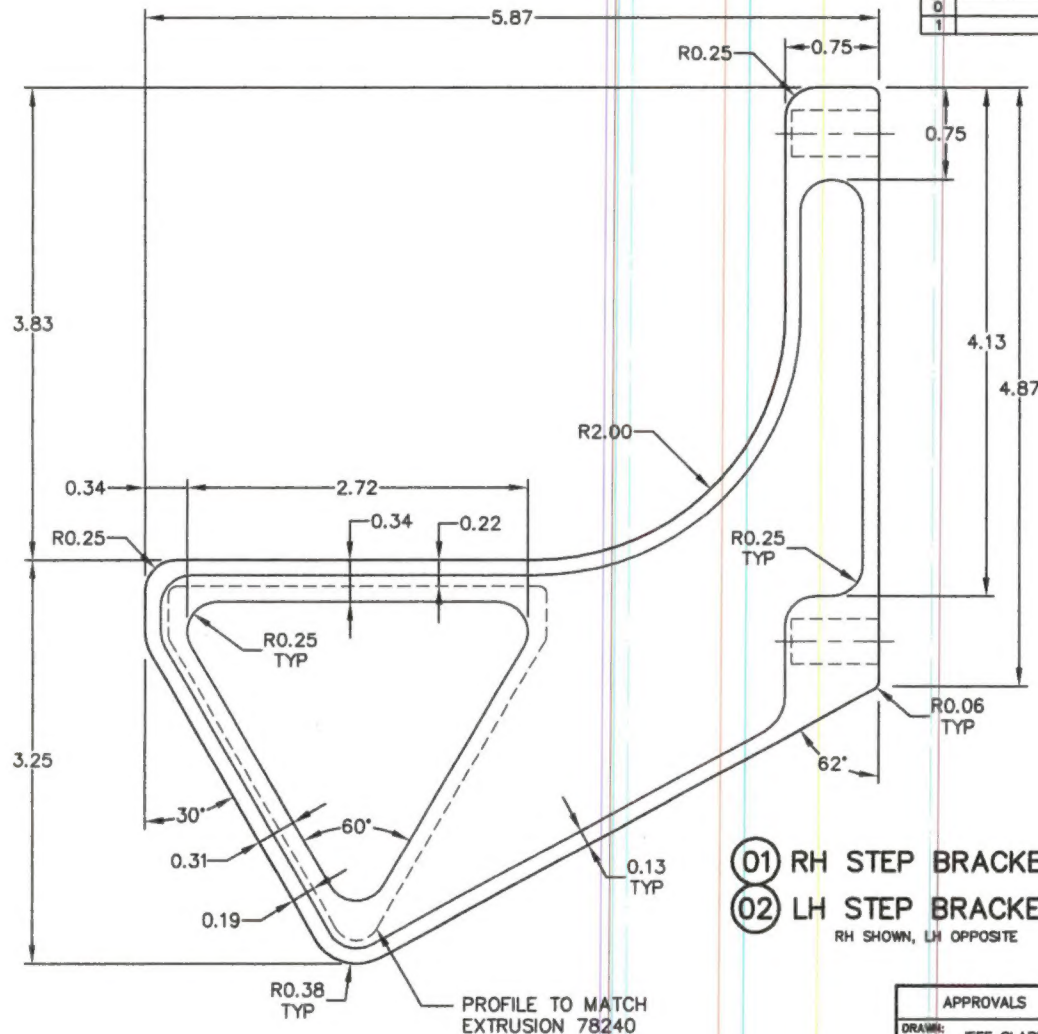
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL
8	NAS1149F0663P		WASHER	
4	96710-01		STUD FITTING	ALT: ANCRA 40088-14
2	96911-05	05	SAFETY-WALK TAPE (1" WIDE)	3M
A/R	78240	04	EXTRUSION	
1	96921-02	03	LH STEP BRACKET	
1	96921-01	02	RH STEP BRACKET	
	96911-01	01	STEP ASSEMBLY	
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL

LIST OF MATERIALS

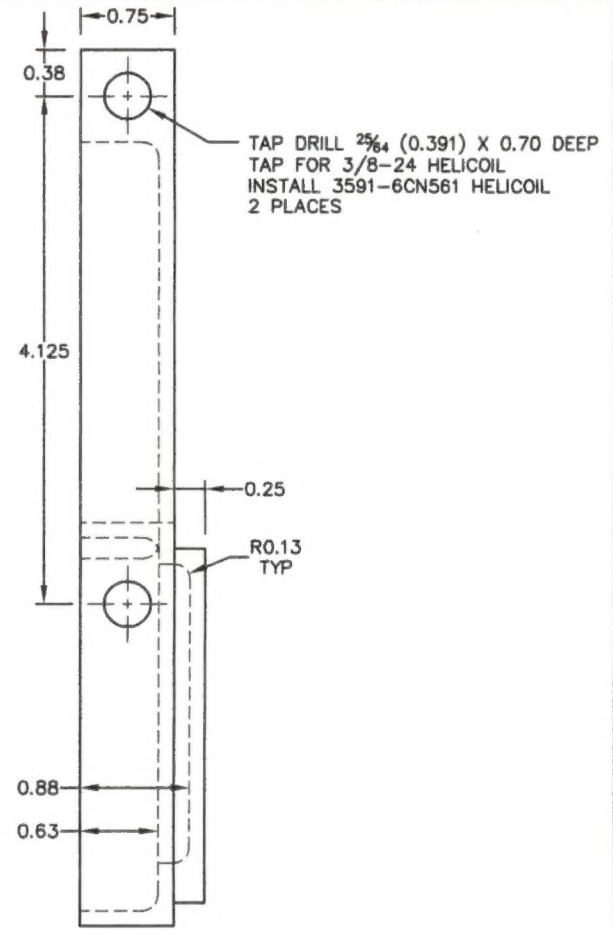
APPROVALS	DATE	 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.485.8276 www.aerodesign.ca			
DRAWN: JEFF CLARKE	28 NOV 2012				
CHECKED: E. BURGAIN	04 DEC 2012				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 429 CABIN STEPS QUICK RELEASE STEP ASSEMBLY			
SCALE 1 : 2		DWG. SIZE	DWG. NO.	REV.	
SHEET 1 OF 1		A3	96911	1	

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED	BJC	08/05/2014



01 RH STEP BRACKET
02 LH STEP BRACKET
RH SHOWN, LH OPPOSITE



QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	2	3591-6CN561	03	SELF-LOCKING HELICOIL			
		96921-02	02	LH STEP BRACKET	6061-T6 ALUMINUM	QQ-A-200/B	6 X 1 BAR
		96921-01	01	RH STEP BRACKET	6061-T6 ALUMINUM	QQ-A-200/B	6 X 1 BAR

LIST OF MATERIALS

APPROVALS	DATE
DRAWN: JEFF CLARKE	28 NOV 2012
CHECKED: E. BURGON	04 DEC 2012

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



AERO DESIGN LTD.
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.488.2376 www.aerodesign.ca

BELL 429 CABIN STEPS QUICK RELEASE STEP BRACKET FABRICATION			
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	96921	1